

Work Order ID 76198 - 2

76198

November-07-11 2:35:31 PM

Item ID: D3137-043
Revision ID:
Item Name: Bracket Assembly

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Start Date: 07/11/2011 Start Qty: 10.00
Required Date: 21/11/2011 Req'd Qty: 10.00

Cust Item ID:
Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: M.C.S.
QC:

Date: 11/11/08 Tooling:

Date:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr Revision Nbr
D3137 Rev F

100
100
Bandsaw
Jeaspa Bandsaw

BAND SAW

Memo
Cut blanks: (.500" x 2.000") 5.570" long

0.00

0.00

110
110
HAAS I
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo
1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-72-Debur3-Scribe batch number

0.00

0.00

120
120
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Work Order ID 76198

76198

November-07-11 2:35:31 PM

Item ID: D3137-043

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Revision ID:

Item Name: Bracket Assembly

Start Date: 07/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***Stop ***NR2***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

J

12-01-17

130

QC

Memo

0.00

Quality Control

140

Small Fab.

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble D3137-043 as per Dwg D3137

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

S12/02/08

12/02/08 (9)

(x9)

Work Order ID 76198

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November-07-11 2:35:31 PM

Item ID: D3137-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 07/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Identify as per dwg & Stock Location: Z35B

0.00

12/2/85

9

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

[Signature]

M.L.J 12/02/09

M.L.J 12/02/09
(9)

Picklist Print

November-07-11 2:35:35 PM

Page 1

Work Order ID: 76198

Parent Item: D3137-043

Parent Item Name: Bracket Assembly

76198

D3137-043

Start Date: 07/11/2011

Start Qty: 10.00

Required Date: 21/11/2011

Required Qty: 10.00

Comments: IPP Rev:A04.02.18New issueKJ/DS
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS24694-S101

MS24694-S101

Screw

Purchased

No

100 Each 15.0000 1 10

**

EP 12/02/08
M119638

Location

Loc Qty

Loc Code

ST289A

15

110363

5

118159

10

140 Each 0.0000 1 10

**

B76873

(9x)

EP 12/02/08

D3137-3

D3137-3

Guide

Manufactured

No

D3137-5

D3137-5

Washer

Manufactured

No

140 Each 8.0000 1 10

**

EP 12/02/08

Location

Loc Qty

Loc Code

ST235B

8

46740

4

68262

4

140 49.7651 0.4643 4.887368

**

3

B77022 (6x)

M174B0.500X02.000

Purchased

No

M174B0.500X02.000

17-4 SS Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT050

49.7651

100843

12.9

103089

13

14932

18.9051

19572

4.96

1.25x *M1210112*

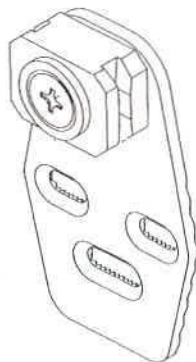
DART AEROSPACE LTD		Work Order: <i>71198</i>
Description: Bracket		Part Number: D3137-7
Inspection Dwg: D3137 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

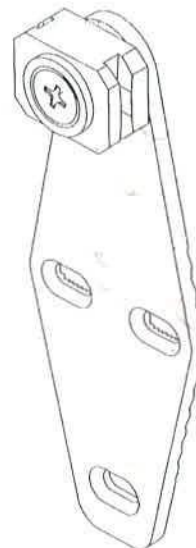
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.560	+0.006/-0.001	.562	/			
5.29	+/-0.030	5.290	/			
2.79	+/-0.030	2.76	/			
0.67	+/-0.030	.67	/			
1.90	+/-0.030	1.888	/			
0.262	+/-0.010	.263	/			
0.062	+/-0.010	.065	/			
4.850	+/-0.010	4.880	/			
0.162	+/-0.010	.160	/			
Ø0.500	+0.006/-0.001					
2.360	+/-0.010	2.361	/			
1.880	+/-0.010	1.878	/			
0.480	+/-0.010	.481	/			

Measured by: <i>DE</i>	Audited by: <i>DL</i>	Preliminary Approval:	N/A
Date: 12-1-16	Date: 12-01-17	Date:	N/A

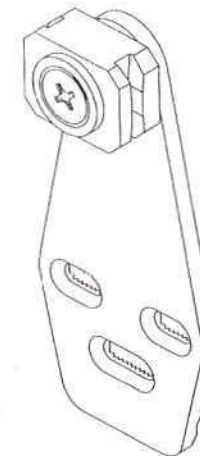
Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	
C	06.03.15	Dwg Rev updated	KJ/JLM	
D	08.12.02	Dwg Rev updated	KJ/DD	
E	10.08.03	Dimension 5.29 was 0.529	KJ	<i>[Signature]</i>



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY

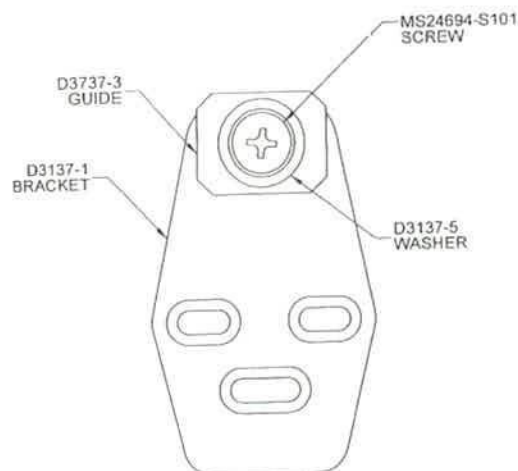


D3137-045 BRACKET ASSEMBLY

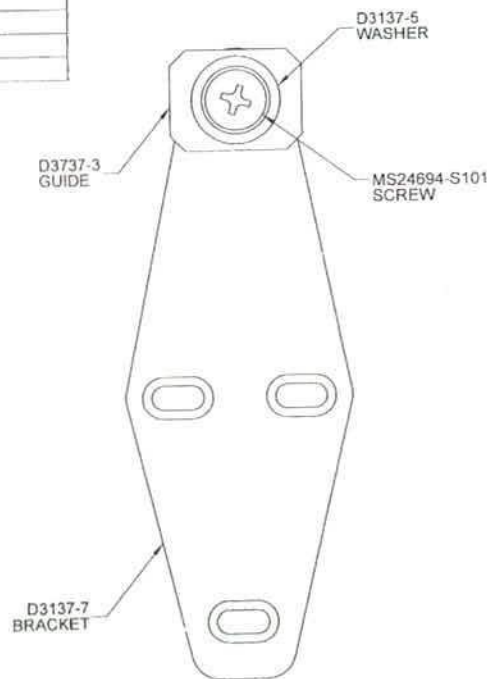
RELEASE
08-06-24

REV.	DESCRIPTION	BY	DATE
F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.605, ZONE A.5 0.67 DIM WAS 0.79, ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.5 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D2137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG APPR.		D3137	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

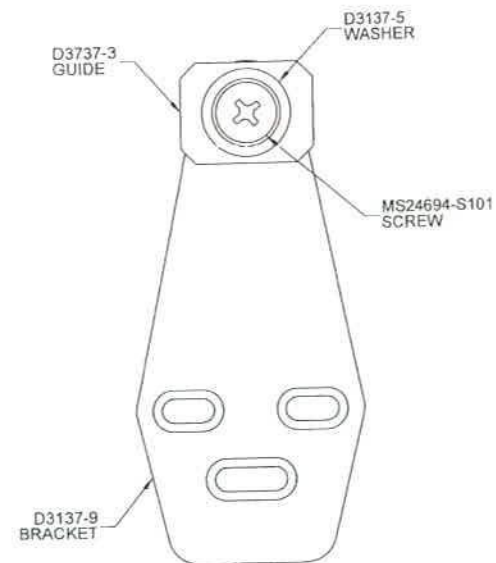
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

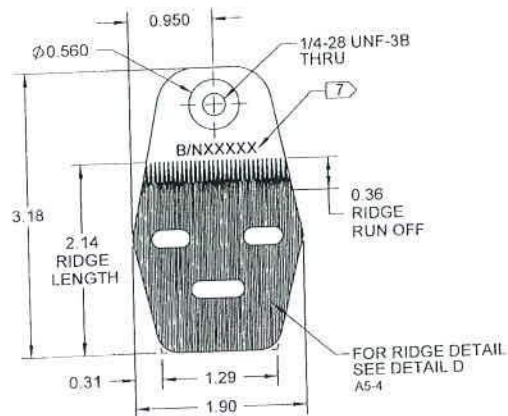
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
0.32 lbs -043
0.27 lbs -045

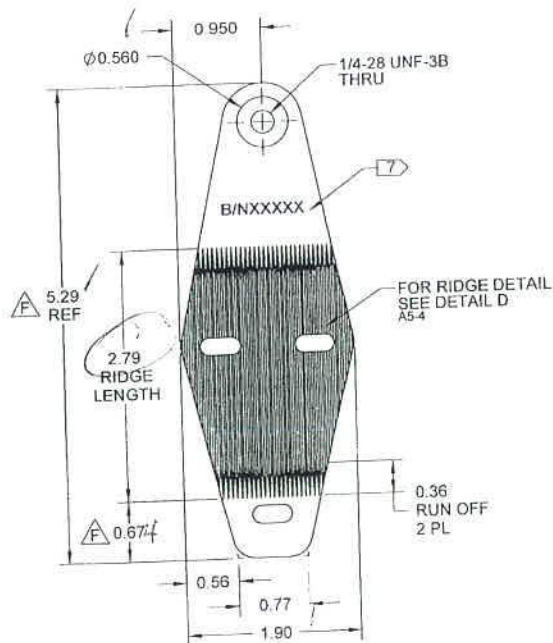
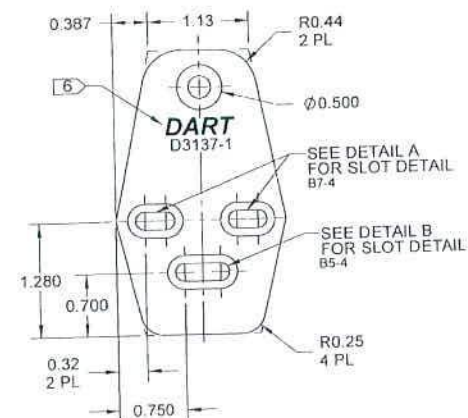
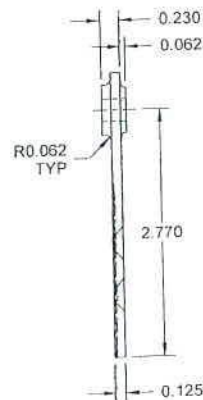
RELEASED
08.06.26/11

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	
DATE	08.05.30	NTS	

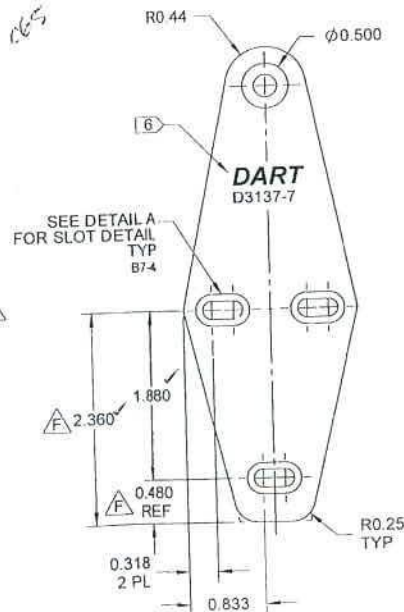
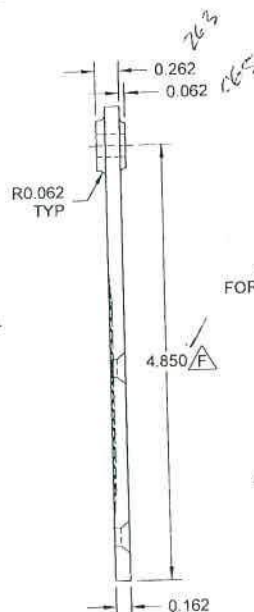
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D3137-1 BRACKET



D3137-7 BRACKET

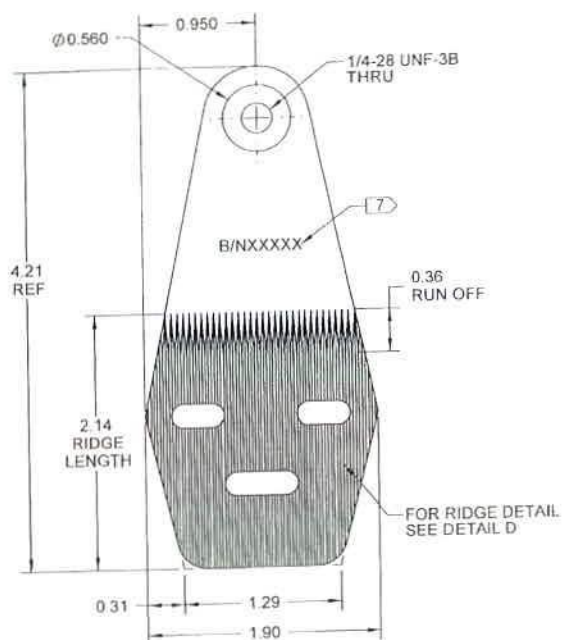


NOTES:

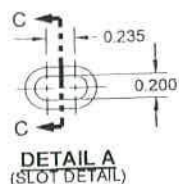
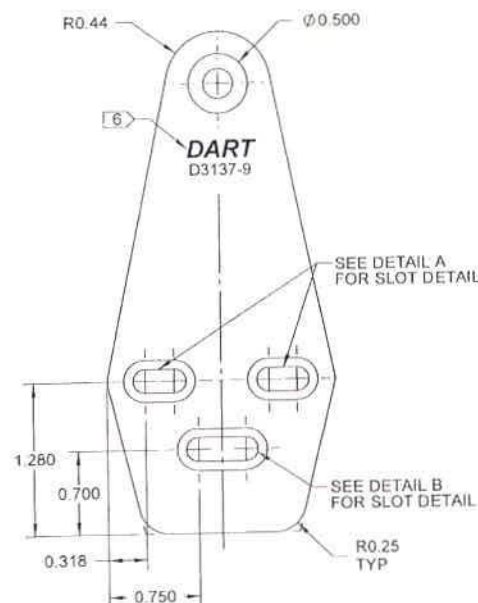
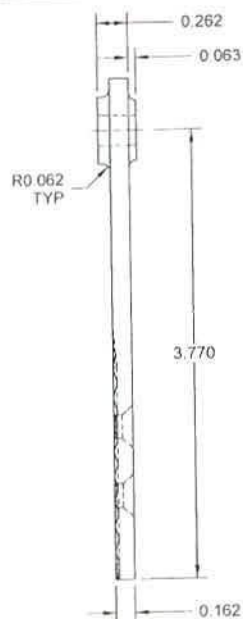
- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-106

RELEASED
ON 06-26-14

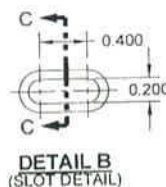
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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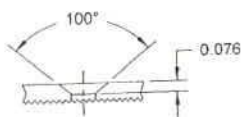
D3137-9 BRACKET



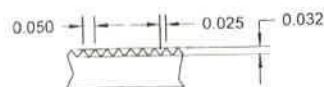
**DETAIL A
(SLOT DETAIL)**



**DETAIL B
(SLOT DETAIL)**



**SECTION C-C
(SLOT DETAIL)**

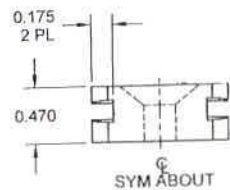
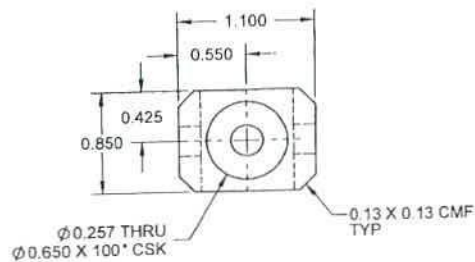


**DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)**

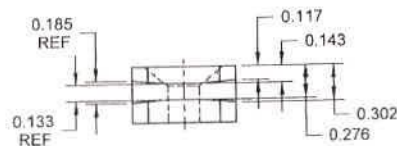
- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
 - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
 - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
 - 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD	

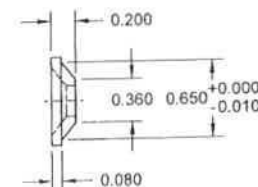
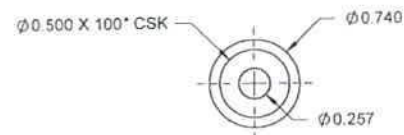
RELEASED



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
- 5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED
08.07.01/14

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
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